

Work Order ID 62686

Wednesday, October 06, 2010 10:51:34 AM

Page 1

Item ID: D2654-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Web

Start Date: 10/6/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-06

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2654	Rev E1								
100	Skidtubes	0.00							
	Memo	0.00							
	1-Cut D2600-7 to length as per Dwg D2654								
	2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654								
	3-Using the uni-bit, open holes to finish size as per Dwg D2654								
	4-Debur holes and ends								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							
	HandFinishing								
120	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

Handwritten notes and signatures:

- Signature: BB, Date: 10/10/14
- Signature: BB, Date: 10/10/14
- Signature: J, Date: 10/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2654-7 PAR #: _____ Fault Category: SKIDS NCR: Yes No DQA: 7 Date: 10/02/1
 Resolution: Re-work Accepted Disposition: use as is QA: N/C Closed: _____ Date: _____

NCR: <u>62686</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-10-14</u>	<u>10D</u>	<u>FWD HOLE</u> <u>DRILLED Ø 0.75 Qty 1</u> <u>web</u> <u>R.C: L00</u>	<u>CP</u> <u>10-10-14</u> <u>QSI/xyz</u>	<u>Acceptable</u>	<u>BB</u> <u>10/10/14</u>	<u>7</u> <u>10/10-21</u>	<u>CP</u> <u>10-10-14</u> <u>QSI/xyz</u>	<u>7</u> <u>10-10-21</u>

NOTE: Date & initial all entries

Work Order ID 62686

Wednesday, October 06, 2010 10:51:34 AM

Page 2

Item ID: D2654-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Web

Start Date: 10/6/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: LL

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/21 AFME
10-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, October 06, 2010 10:51:38 AM

Page 1

Work Order ID: 62686

Parent Item: D2654-7

Parent Item Name: Web



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM□
IPP Rev:e□06.04.05 Added level21 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-7-140

Manufactured

No

100

Each

46.0000

1

4



Handwritten signature

EXT. "I BEAM" THICK

Location

Loc Qty

Loc Code

LG

46

41591

46

4

BB 10/19/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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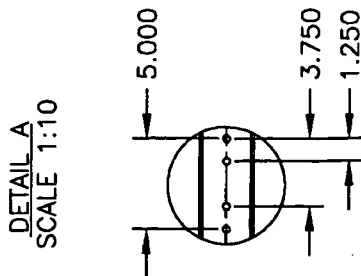
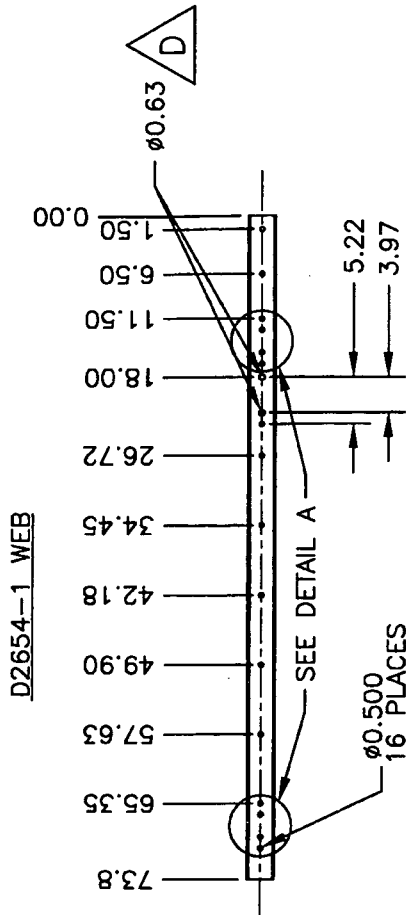
NOTE: Date & initial all entries

DART
DEO ATTACHED

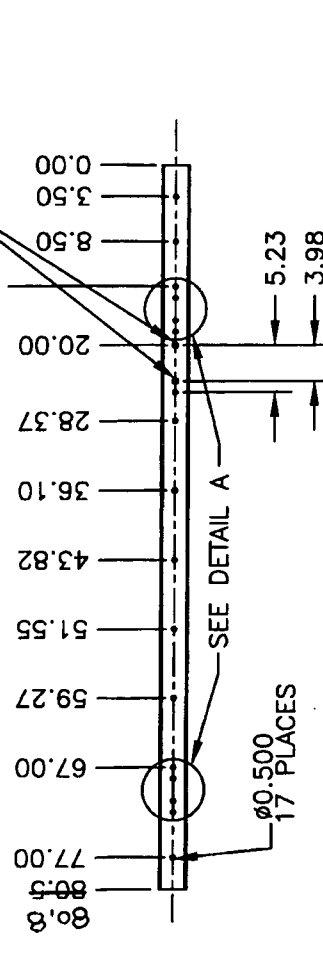


DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE	04.05.26			TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	<i>CP</i> 04.08.04	PER TOOLING; 80.8 WAS 80.5			

RELEASED
04.06.22



2101006
UNCONTROLLED COPY
SUBJECT TO WORK ORDER NO. *2101006*
D2654-3 WEB



MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

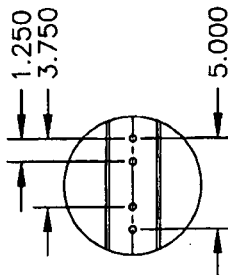
NOTE: Date & initial all entries



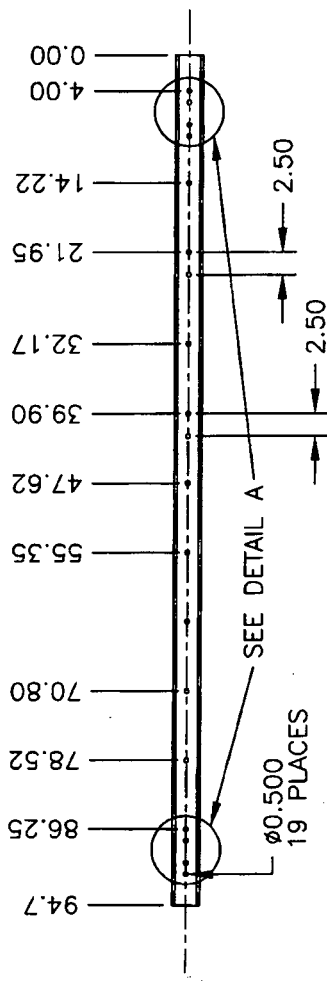
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26	TITLE WEB	SCALE 1:20	

RELEASED
04.06.22
DEO ATTACHED

DETAIL A
SCALE 1:10

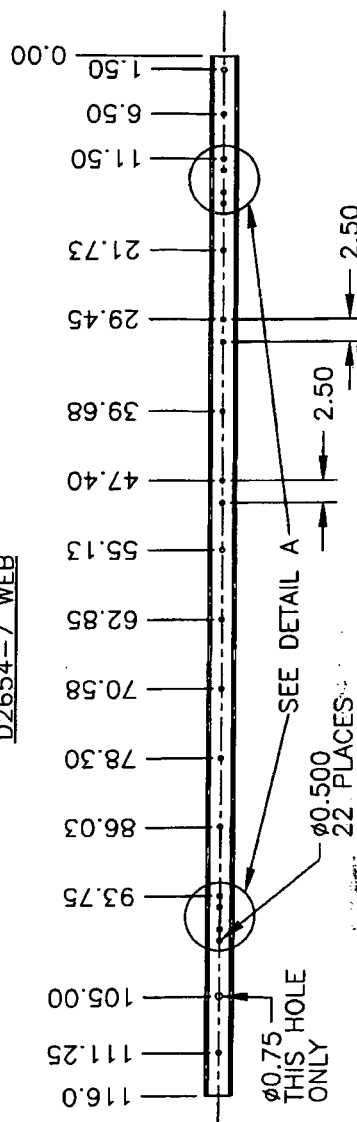


D2654-5 WEB



w/o 62654

D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

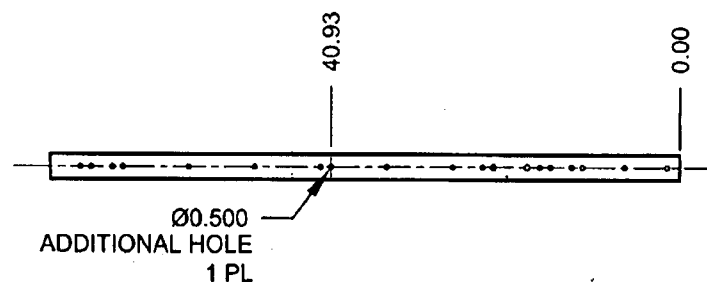
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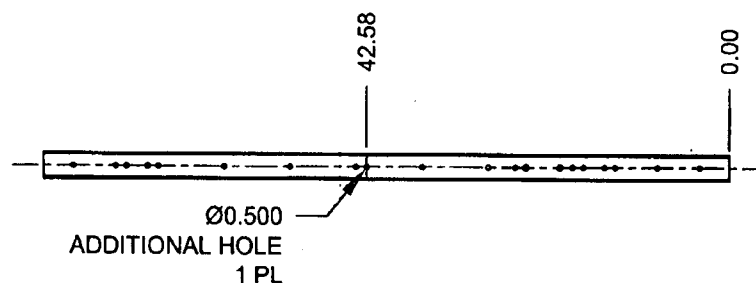
DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>W</i>		DE APPR. <i>H</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03		DATE 09.04.03		

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *W*



D2654-1 WEB



D2654-3 WEB

WLO 62686

THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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